

Date: Monday, 02/03/2009 9:05:07 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STRUT WELDMENT ASS'Y
<b>Job Number</b> : 46142	
<b>Estimate Number</b> : 10566	
<b>P.O. Number</b> :	<b>Part Number</b> : D34435
<b>This Issue</b> : 02/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3443 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 44030	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/03/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JWD 09.03.02</u>	
<b>Comment</b> : A 05.11.14 New issue EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M304TR0750W120

304-ss round tube .750 x .120w



(20)

**Comment:** Qty.: 0.5198 f(s)/Unit Total: 10.3950 f(s)

Inventory

AISI 304 SS seamless tubing .750 OD x 0.120 wall

(M304TR0750W120)

Batch: M110096 (x19)M110097 (x1)

H.A 09/03/11

2.0

BAND SAW

BAND SAW



(20)

**Comment:** BAND SAW

1-Cut blank 5.97 " long

2-Deburr

H.A 09/03/11

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



(20)

**Comment:** CONVENTIONAL MILLING MACHINE

1- Mill to length and drill holes as per dwg D3443

2-Deburr as per dwg D3443

H.A 09/03/11

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(20)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/03/11

5.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

84 09/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 9:05:07 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46142

Part Number: D34435

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



420

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *MISC*

*Lpl 09-03-12*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

*09/03/13*

Job Completion



*MF 09-03-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

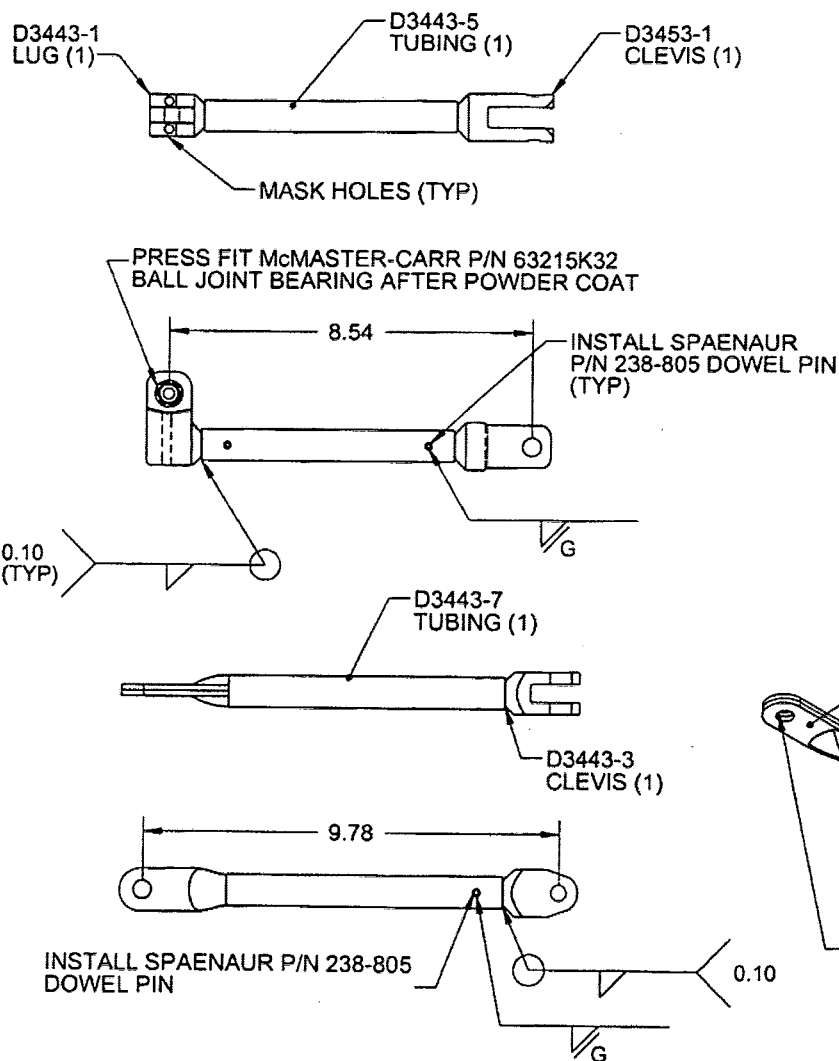




DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

**RELEASED**

05.12.09 *[Signature]*



**D3443-041**

SHOP COPY  
**D3443-043** RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. *6042*

**NOTES:**

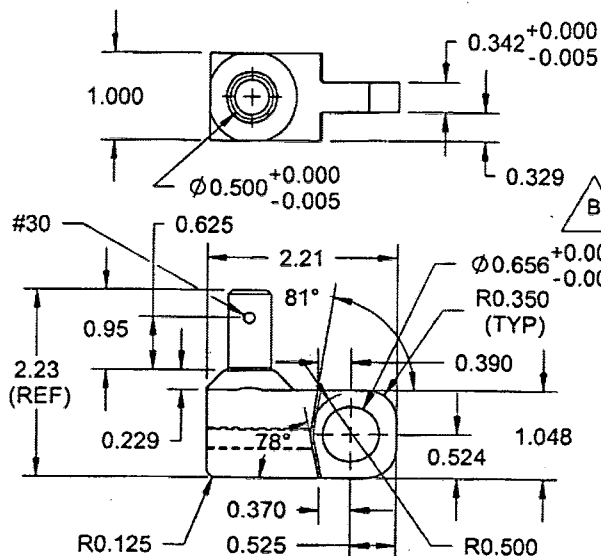
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 12		



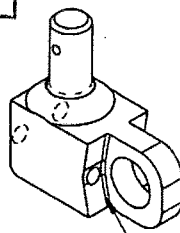
RELEASED

05.12.04 *[Signature]*

0.05 x 45  
CHAMFER

R0.032

0.470 (TYP)



R0.032  
(TYP)

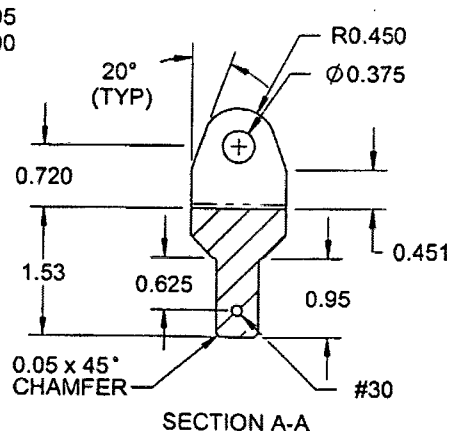
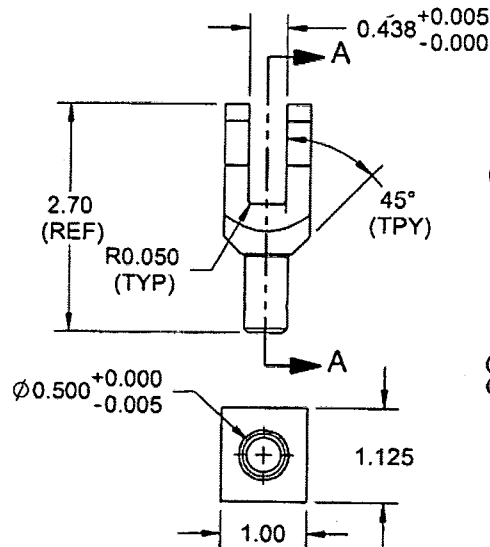
1/4-28 UNF 2B  
(2 PLACES)

0.165 (TYP)

**D3443-1 LUG**

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



**D3443-3 CLEVIS**

**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 4642

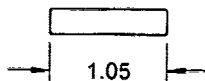
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



**D3443-9 PIN**

**D3443-9 NOTES:**

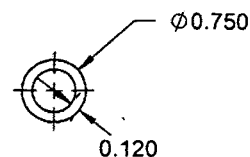
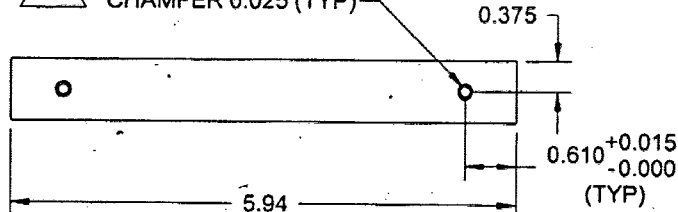
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.09 [Signature]

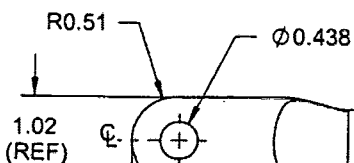
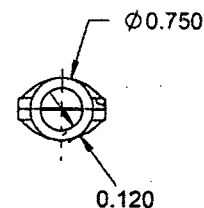
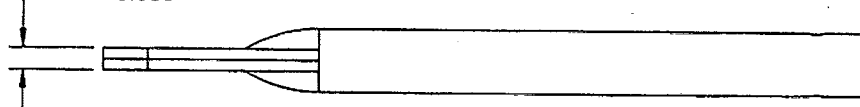


DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)



**D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$



DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025

**D3443-7 TUBING**

**D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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